



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RB877206-5
Job Sheet 195956



Part No: RB877206-5

Job Qty: 1 pcs

Part Name: Swashplate Bearing Cutter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/3/19

Job Tracking No:

Due Date: 8/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB877206-5 REV 4A IPP REV A 18.02.21 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	8/1/19		0.00	1.00	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	8/1/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
130	Packaging 3-1 - Stock - B4B	1 pcs	8/1/19		0.00	0.00	QC 5 - 50		DAS 40 JUL 26 2019 9-89
							QC 5 - 30		
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		JP
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S200661



Part: RB877206-5

Job No: 195956

Serial No/Batch: S200661

Revision: 4A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
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Date: 07/25/19

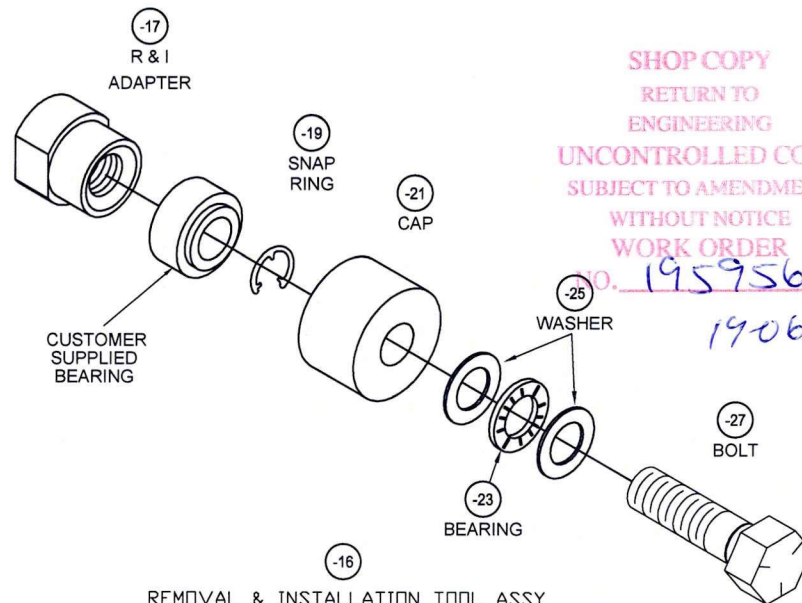
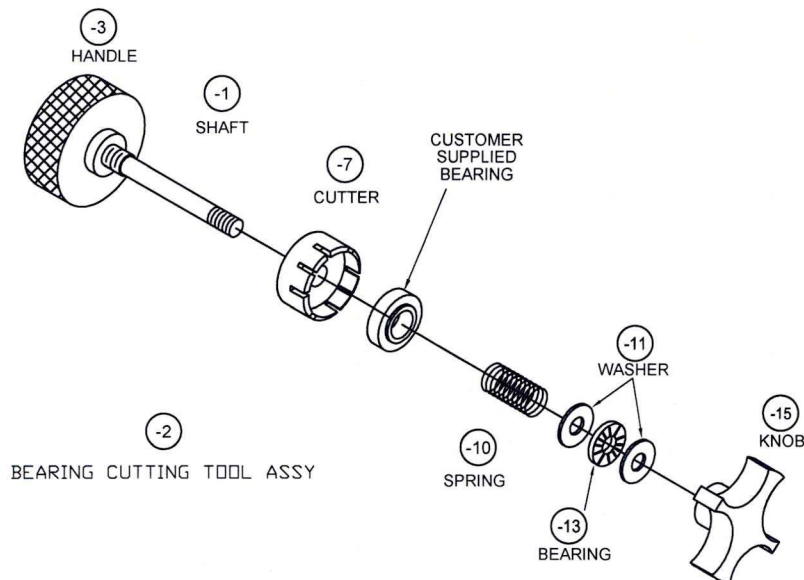
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					Packaging 3 - 8 - B4B			
					Packaging 3 - 9 - B4B			
					Packaging 3 - 10 - B4B			
					Packaging 3 - 11 - B4B			
					Packaging 3 - 12 - B4B			
					Packaging 3 - 13 - B4B			
					Packaging 3 - 14 - B4B			
					Packaging 3 - 15 - B4B			
					Packaging 3 - 16 - B4B			
					Packaging 3 - 17 - B4B			
					Packaging 3 - 18 - B4B			
					Packaging 3 - 19 - B4B			
					Packaging 3 - 20 - B4B			
					Packaging 3 - 21 - B4B			
					Packaging 3 - 22 - B4B			
					Packaging 3 - 23 - B4B			
					Packaging 3 - 24 - B4B			
					Packaging 3 - 25 - B4B			
					Packaging 3 - 26 - B4B			
					Packaging 3 - 27 - B4B			
					Packaging 3 - 28 - B4B			
					Packaging 3 - 29 - B4B			
					Packaging 3 - 30 - B4B			
					Packaging 3 - 31 - B4B			
					Packaging 3 - 32 - B4B			
					Packaging 3 - 33 - B4B			
					Packaging 3 - 34 - B4B			
					Packaging 3 - 35 - B4B			
					Packaging 3 - 36 - B4B			
140	QC 21 - FG	1 pcs	8/1/19	0.00 0.00	QC 21 - FG - 21			
					QC 21 - FG - 70	JUL 26 2019		
					QC 21 - SA - 53			
Part Op 110 - (Small Fab) 1-Assemble as per DWG. Sheet 1. Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) Bag and Tag 140 - (QC21- Final Inspection - Work Order Release)								
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
RB877206-5-16	Swashplate Bearing Install/Removal Set	1 pcs (1 ea)	110-Small Fab - 1		5199809			
RB877206-5-2	Bearing Cutter Tool Assembly	1 pcs (1 ea)	110-Small Fab - 1		5199838			
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
110-Small Fab - 1	RB877206-5-16	1	0	0				
	RB877206-5-2	1	0	0				
Part Specifications								
Specifications could not be found.								

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/04		
2	CH'D -7 PREGRIND TOLERANCE FROM .953.	1/2/08	WP	G.E.
3	ADDED AN 8" HOOK TO CUTTING TEETH, WAS STRAIGHT WITH NO HOOK.	1/29/08	WP	DW
4	CH'D -27 GROOVE NOMENCLATURE FROM .032 W x .025 DP.	1/29/08	WP	GE
4A	CH'D TITLEBLOCK & REVISION BLOCK, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/29/09	RJC	RW



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WORK ORDER

NO. 195956 MLS
1906-03

NOTE:
BEARING #206-010-469-001, 206-010-470-001, ASTRO AM2004DHS

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		SHAFT	STRESS PROOF	Ø3/4 x 4	2
	1		-2	1	BEARING CUTTER TOOL ASSY			1
	1		-3		HANDLE	6061 T6	Ø2 x 3/4	2
	1		-7		CUTTER	01	Ø1 x 5/8	3
	1	B/O	-10		SPRING		5/16 x 2 (EUGENE FASTNER #16)	1
	2	B/O	-11		WASHER		TRA-512 (APPLIED INDUSTRIAL)	1
	1	B/O	-13		BEARING		NTA512 (APPLIED INDUSTRIAL)	1
	1	B/O	-15		KNOB		DK-55 (REID TOOL)	1
	1		-16	1	REMOVAL & INSTALLATION TOOL ASSY			1
	1		-17		R&I ADAPTER	STRESS PROOF	Ø1-1/4 x 1-1/4	4
	1	B/O	-19		SNAP RING		Ø5/16 EXTERNAL	1
	1		-21		CAP	6061 T6	Ø1-1/2 x 1	4
	1	B/O	-23		BEARING		NTA512 (APPLIED INDUSTRIAL)	1
	2	B/O	-25		WASHER		TRA-512 (APPLIED INDUSTRIAL)	1
	1		-27		BOLT	GRADE 5	5/16-24 UNF x 3 MODIFY	4
ASSY -16	ASSY -2							

RED BARN MACHINE	
TITLE BEARING CUTTER	
DWG NO. RB877206-5	REV 4A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
SHEET 1 of 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					